

Date: Wednesday, 1/4/2006 2:37:04 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|---------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : STRUT |
| Job Number | : 25394 | | |
| Estimate Number | : 10988 | | |
| P.O. Number | : N/A | Part Number | : D2565411 |
| This Issue | : 1/4/2006 | S.O. No. | : N/A |
| Prsht Rev. | : NC | Drawing Number | : D2565 REV E |
| First Issue | : N/A | Project Number | : N/A |
| Previous Run | : N/A | Drawing Revision | : E |
| | Type : SMALL / MED FAB | Material | : N/A |
| Written By | : <u>SEE COMMENT BELOW</u> | Due Date | : 1/20/2006 |
| Checked & Approved By | : " " " | Qty: | 7 Um: Each |
| Comment | : Est:A 04.05.10 New Issue KJ/JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TR0750W049 | 304 RD Tube .750 x .049W |
|-----|----------------|--------------------------|



Comment: Qty.: 1.2950 f(s)/Unit Total : 10.3597 f(s)

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall

(M304TR0750W049)

Batch No: M18983

| | | |
|-----|----------|----------|
| 2.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: BRAKE NC

Punch as per Dwg D2565 using DT 8313

FF 06.01.12 8

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

ml 06/01/16
D2565/12 8

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

206.01.23

| | | |
|-----|----------------|----------------|
| 5.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



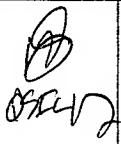
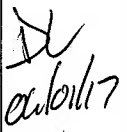
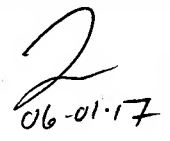
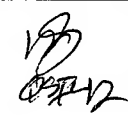
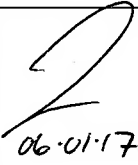
Comment: POWDER COATING

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

a.m 06-02-14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 1 Date: 06/02/16
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|---|--|---------------------------------|--|--|---|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06-01-17 | 3 | hole, 316 drilled in strut my mistake. Hole not required for A - 411 strut. |  | strap: destroyed |  06/01/17 |  06-01-17 |  |  06-01-17 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 1/4/2006 2:37:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 25394

Part Number: D2565411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

NA 06/02/15

7

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 189

C 206/02/15

(7)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUE 06/02/16

(7)

SP 06/02/16

(7)

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

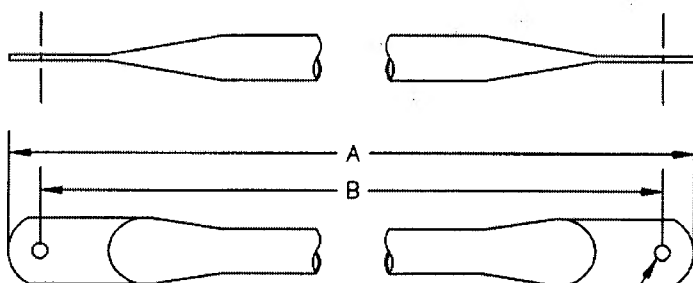
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| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|------------------|----------|---|------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D2565 | REV. E SHEET 1 OF 1 |
| DATE 04.05.05 | | TITLE STRUT | SCALE 1:3 |
| A | 96.05.03 | NEW ISSUE | |
| B | 97.03.15 | CORRECT D2565-111 DIM. A | |
| C | 98.10.05 | UPDATED MATERIAL NOTE (TSR A603) | |
| D | 02.06.05 | ADD -3XX PARTS; ADD FINISH | |
| E | 04.05.05 | ADD D2565-401-411; RMV ANGLE D | |

RELEASED
04.05.05



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

| PART # | A | B | DIA C |
|-----------|-------|-------|-------|
| D2565-101 | 20.52 | 19.72 | 0.316 |
| D2565-103 | 18.21 | 17.41 | 0.316 |
| D2565-105 | 20.19 | 19.39 | 0.316 |
| D2565-107 | 13.43 | 12.63 | - |
| D2565-109 | 12.31 | 11.51 | - |
| D2565-111 | 13.65 | 12.85 | - |
| D2565-201 | 22.79 | 22.00 | 0.316 |
| D2565-203 | 20.75 | 19.95 | 0.316 |
| D2565-205 | 21.22 | 20.42 | 0.316 |
| D2565-207 | 16.07 | 15.27 | - |
| D2565-209 | 15.16 | 14.36 | - |
| D2565-211 | 14.14 | 13.34 | - |
| D2565-301 | 27.03 | 26.23 | 0.316 |
| D2565-303 | 25.34 | 24.54 | 0.316 |
| D2565-305 | 23.73 | 22.93 | 0.316 |
| D2565-307 | 20.86 | 20.06 | - |
| D2565-309 | 20.17 | 19.37 | - |
| D2565-311 | 16.30 | 15.50 | - |
| D2565-401 | 18.29 | 17.49 | 0.316 |
| D2565-403 | 15.64 | 14.84 | 0.316 |
| D2565-405 | 19.45 | 18.65 | 0.316 |
| D2565-407 | 10.79 | 9.99 | - |
| D2565-409 | 9.34 | 8.54 | - |
| D2565-411 | 13.81 | 13.01 | - |

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
25394

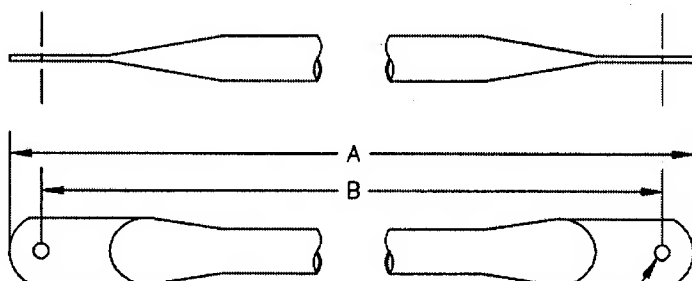
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| | | | |
|------------------|----------|---|------------------------|
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| CHECKED | APPROVED | DRAWING NO. D2565 | REV. E SHEET 1 OF 1 |
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| E | 04.05.05 | ADD D2565-401-411; RMV ANGLE D | |

RELEASED
04.05.05



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| D2565-103 | 18.21 | 17.41 | 0.316 |
| D2565-105 | 20.19 | 19.39 | 0.316 |
| D2565-107 | 13.43 | 12.63 | - |
| D2565-109 | 12.31 | 11.51 | - |
| D2565-111 | 13.65 | 12.85 | - |
| D2565-201 | 22.79 | 22.00 | 0.316 |
| D2565-203 | 20.75 | 19.95 | 0.316 |
| D2565-205 | 21.22 | 20.42 | 0.316 |
| D2565-207 | 16.07 | 15.27 | - |
| D2565-209 | 15.16 | 14.36 | - |
| D2565-211 | 14.14 | 13.34 | - |
| D2565-301 | 27.03 | 26.23 | 0.316 |
| D2565-303 | 25.34 | 24.54 | 0.316 |
| D2565-305 | 23.73 | 22.93 | 0.316 |
| D2565-307 | 20.86 | 20.06 | - |
| D2565-309 | 20.17 | 19.37 | - |
| D2565-311 | 16.30 | 15.50 | - |
| D2565-401 | 18.29 | 17.49 | 0.316 |
| D2565-403 | 15.64 | 14.84 | 0.316 |
| D2565-405 | 19.45 | 18.65 | 0.316 |
| D2565-407 | 10.79 | 9.99 | - |
| D2565-409 | 9.34 | 8.54 | - |
| D2565-411 | 13.81 | 13.01 | - |

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- 4) ALL DIMENSIONS ARE IN INCHES

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